


Sept 4 12

Dart Aerospace Ltd.

Date: Tuesday, 15/08/2006 7:16:49 AM
User: Linda Lacelle











Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 28157		
Estimate Number	: 11028		
P.O. Number	: N/A	Part Number	: D28022
This Issue	: 15/08/2006 S.O. No. : N/A	Drawing Number	: D2802 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 25709	Material	: N/A
Written By	:	Due Date	: 08/09/2006 Qty: 14 Um: Each
Checked & Approved By	: 		
Comment	: Est:B 02.03.18 Re-format NG Est:C 06.02.13 Removed p/c EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"
		
Comment: Qty.: 1.5750 f(s)/Unit Total : 22.0500 f(s) 6061-T6 Bar .50" x 6.0" Material: 6061-T6 bar 6.00" x 0.50" Batch: M10147 X 3 M101422 X 11 J.G 06/08/16 14		
2.0	BAND SAW	BAND SAW
		
Comment: BAND SAW Cut blanks 17.800" long J.G 06/08/16 14		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		
Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio FA101 Counter sink .375 dia as per dwg J.L 06/08/20 14		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE J.L 06/08/20 14		
5.0	QC8	SECOND CHECK
		
Comment: SECOND CHECK J.C 06.08.22 14		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/08/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/08/2006 7:16:49 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 28157

Part Number: D28022

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble & Deburr NO sharp edges.

SA 06.08.23

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SA 06.08.23

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA28

SA 06.08.23

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SA 06.08.23

Job Completion



U 06.08.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

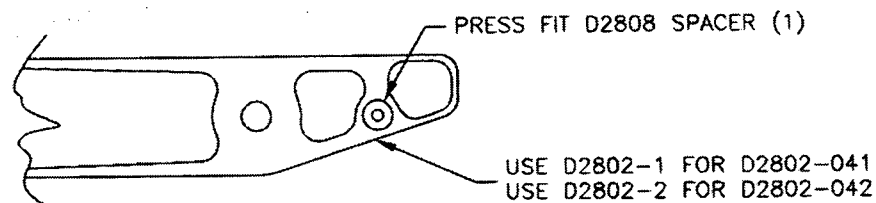
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

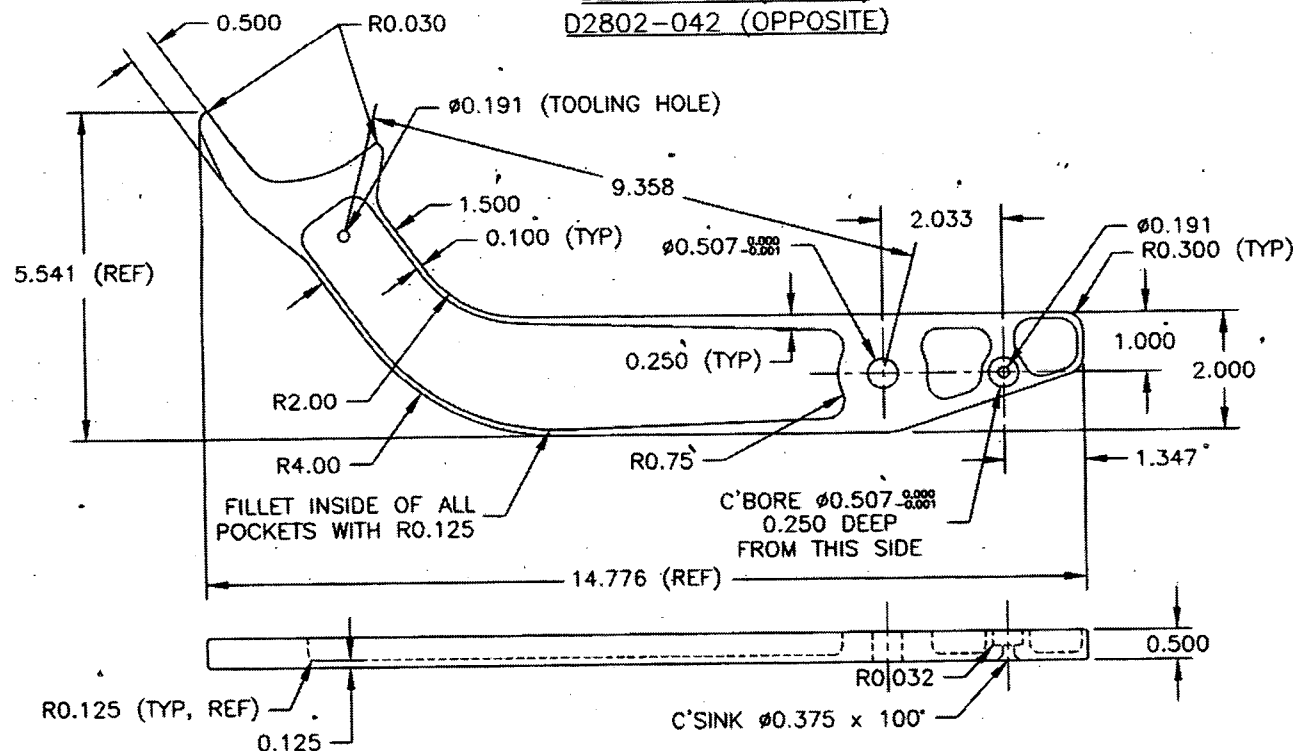
DART



DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>CP</i>	APPROVED <i>CP</i>	HAMKESBURY, ONTARIO, CANADA
DATE 00.11.03	DRAWING NO. D2802	REV. A
	TITLE ARM	SHEET 1 OF 1
A	00.11.03	SCALE 1:3
	NEW ISSUE	



D2802-041 (SHOWN)
D2802-042 (OPPOSITE)



D2802-1 (SHOWN)
D2802-2 (OPPOSITE)

MACHINE PER DRAWING FILE "D2802-A1.DWG"
MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK (REF)
DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
00-11-13

DART AEROSPACE LTD		Work Order: 28157
Description: arm		Part Number: D2802-2
Inspection Dwg: D2802 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

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First Article

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Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.500	$\pm .010$.505	✓			
r.030	"	.030	✓			
Ø.191	$\begin{matrix} +.005 \\ -.001 \end{matrix}$.193	✓			
1.500	$\pm .010$	1.502	✓			
.100	"	.100	✓			
9.358	"	9.358	✓			
Ø.507	$\begin{matrix} +0 \\ -.001 \end{matrix}$.5066	✓			
2.033	$\pm .010$	2.033	✓			
1.000	"	1.000	✓			
2.000	"	2.002	✓			
1.347	"	1.348	✓			
.507X.250	"	.5065X.250	✓			
.250	"	.250	✓			
r.75	$\pm .030$.75	✓			
r.125	$\pm .010$.125	✓			
.125	$\pm .010$.128	✓			
r.032	"	.032	✓			
.500	"	.503	✓			
.375X100°	$\pm .010 \pm .1^\circ$.375X100°	✓			

Measured by: J.L. [Signature]	Audited by: Ep	Prototype Approval: N/A
Date: 06/08/20	Date: 06/08/20	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	